

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013495**Date Inspected:** 14-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 100**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Tian lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**BAY#1**

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Repair welding of a weld joint # 003 according to weld repair report #B-WR11659 located on Traveler Rail 21TR2 – 002. Welder is identified as 251246. ZPMC Quality Control (QC) Inspector is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) – Repair – 1.

Weld joint # 009 located on Traveler Rail 20TR1 – 043. Welder is identified as 059450. ZPMC Quality Control (QC) Inspector is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F.

Repair welding of a weld joint # 003 according to weld repair report #B-WR11656 located on Traveler Rail 21TR3 – 001. Welder is identified as 216575. ZPMC Quality Control (QC) Inspector is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) – Repair – 1.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

Weld joint # 003 located on Traveler Rail 20TR1 – 038. Welder is identified as 216872. ZPMC Quality Control (QC) Inspector is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F.

BAY#2

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Repair welding of a weld joint # 001 according to weld repair report #B-WR11943 located on Traveler Rail 20TR1 – 010. Welder is identified as 045276. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) – Repair – 1.

Weld joint # 003 located on Floor Beam FB3191 – 001. Welder is identified as 045203. ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2a – F – 1.

Repair welding of a weld joint # 001 according to weld repair report #B-WR11947 located on Traveler Rail 20TR1 – 009. Welder is identified as 045209. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) – Repair – 1.

Submerged Arc Welding (SAW):

Weld joint # 001 located on Floor Beam FB3188 – 001. Welder is identified as 045270. ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2. (See attached photo)

BAY#3

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005522

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

TRAVELER RAIL

1. 11TR2 – 013 – 007; 010; 014
2. 10TR3 – 038 – 007; 010; 014
3. 10TR3 – 015 – 007; 010; 014
4. 11TR1 – 020 – 007; 010; 014
5. 11TR1 – 021 – 007; 010; 014
6. 11TR1 – 014 – 007; 010; 014

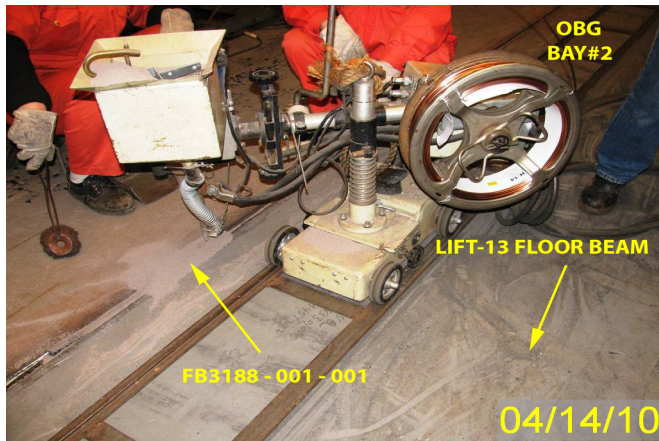
---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Kumar,Sandeep
----------------------	---------------

Quality Assurance Inspector
-----------------------------

---

<b>Reviewed By:</b>	Hall,Steven
---------------------	-------------

QA Reviewer
-------------